



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

646.9713

Job Sheet 205052



Part No: 646.9713

Job Qty: 20 pcs

Part Name: Body



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/27/19

Job Tracking No:

Due Date: 3/30/20

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG 646.9700 REV.H IPP Rev.A New issue JFS 16/03/08 Verify by: JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	20 pcs	3/30/20		0.00	3.42	Bandsaw - 1	DAS 6N 20-03-10	
110	HAAS 4 Axis - B4B	20 pcs	3/30/20		0.60	29.41	HAAS - 1 - B4B	52 20/03/15	
							HAAS - 2 - B4B	9-89	
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
120	QC 2	20 pcs	3/30/20		0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51	DAS	
							QC 2 - 52	52 20/03/15	
							QC 2 - 57	9-89	
							QC 2 - 62		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S263677



Part: 646.9713

Job No: 205052

Serial No/Batch: S263677

Revision: H

Inspector:

Exp Date:

Instructions:

Date: 03/15/20

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130 QC 8	20 pcs	3/30/20	0.00 0.00	QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	OK 20/03/15
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
140 Outsource - 4 - Anodize	20 pcs	3/30/20	0.00 0.00	QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
				ATG001-VC	5
150 Packaging 2-1 - Receive - B4B	20 pcs	3/30/20	0.00 0.00	Packaging 2 - 1 - B4B	OK 2020-03-16
				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	OK APR 02 2020
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 -	

					B4B	
					Packaging 2 - 17 - B4B	
					Packaging 2 - 18 - B4B	
					Packaging 2 - 19 - B4B	
					Packaging 2 - 20 - B4B	
					Packaging 2 - 21 - B4B	
					Packaging 2 - 22 - B4B	
					Packaging 2 - 23 - B4B	
					Packaging 2 - 24 - B4B	
					Packaging 2 - 25 - B4B	
					Packaging 2 - 26 - B4B	
					Packaging 2 - 27 - B4B	
					Packaging 2 - 28 - B4B	
					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
					Packaging 2 - 37 - B4B	
155	QC 6	20 pcs	3/30/20	0.00 0.00	QC 6 - 9	
					QC 6 - 68	
					QC 6 - 61	
					QC 6 - 40	APR 30 2020 DAS 40 9-89
					QC 6 - 81	
180	Packaging 3-1 - Stock - B4B	20 ✓ pcs	3/30/20	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B ✓	DAS 80 9-89
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	MAY 01 2020
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
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				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
190 QC 21 - SA	20 pcs	3/30/20	0.00 0.00	QC 21 - SA - 21	D4S 21
				QC 21 - SA - 70	9-85
				QC 21 - SA - 53	MAY 04 2020

Part Op 100 - (Bandsaw) Cut Blank at 7.425"

Descriptions: 110 - (HAAS CNC Vertical Machine) 1-Machine per folio FB464

120 - (QC2- Inspect parts off machine FAI/FAIB)

130 - (QC8- Inspect parts - second check)

140 - Issue P/O to ATG : 46107 Anodize, Color Black, Prime as per Dwg 646.9700

150 - (Receive & Inspect for Damage & Mat'l Certs)

155 - (QC6- All purchased or subcontracted products)

180 - (Identify as per dwg & Stock Location: _____) ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

190 - (QC21- Final Inspection - Work Order Release)

MAT
USED
12.458'

Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M7075T6S1.000X5.000	7075-T6 Sheet1" Thick Plate X 5" Wide	12 ft (.6 ea)	100-Bandsaw - 1	5256977	

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M7075T6S1.000X5.000	12	21	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Body	0.487Inches ± 0.005	0.492 0.482	0.498	
2	Body	4.784Inches ± 0.002	4.786 4.782	4.784	
3	Body	3.603Inches ± 0.002	3.605 3.601	3.603	
4	Body	2.422Inches ± 0.002	2.424 2.420	2.422	
5	Body	1.400Inches ± 0.002	1.402 1.398	1.400	
6	Body	0.375Inches ± 0.002	0.377 0.373	0.375	
7	Body	0.409Inches ± 0.002	0.411 0.407	0.416	
8	Body	0.350Inches ± 0.005 - 0.000	0.355 0.350	0.352	
9	Body	0.875Inches ± 0.005	0.880 0.870	0.879	
10	Body	1.067Inches ± 0.002	1.069 1.065	1.067	
11	Body	2.608Inches ± 0.002	2.610 2.606	2.608	
12	Body	2.750Inches ± 0.002	2.752 2.748	2.750	
13	Body	2.892Inches ± 0.002	2.894 2.890	2.892	
14	Body	3.348Inches ± 0.002	3.350 3.346	3.348	
15	Body	3.597Inches ± 0.002	3.599 3.595	3.598	
16	Body	3.847Inches ± 0.002	3.849 3.845	3.848	
17	Body	0.544Inches ± 0.002	0.546 0.542	0.543	
18	Body	2.195Inches ± 0.002	2.197 2.193	2.195	
19	Body	3.395Inches ± 0.002	3.397 3.393	3.395	
20	Body	3.495Inches ± 0.002	3.497 3.493	3.495	
21	Body	4.595Inches ± 0.002	4.597 4.593	4.595	
22	Body	4.687Inches ± 0.002	4.689 4.685	4.687	
23	Body	4.734Inches ± 0.002	4.736 4.732	4.733	
24	Body	0.177Inches ± 0.005 - 0.001	0.182 0.176	0.177	
25	Body	0.201Inches ± 0.005 - 0.001	0.206 0.200	0.201	
26	Body	0.130Inches ± 0.010	0.140	0.130	

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			0.120	
27	Body	45.0Angle ± 0.5	45.5 44.5	45°
28	Body	1.5Angle ± 0.0	1.5 1.5	1.500
29	Body	0.660Inches ± 0.005	0.665 0.655	0.660
30	Body	0.660Inches ± 0.005	0.665 0.655	0.660
31	Body	0.700Inches ± 0.005	0.705 0.695	0.700
32	Body	5.500Inches ± 0.005	5.505 5.495	5.500
33	Body	6.8Angle ± 0.5	7.3 6.3	6.8°

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **POHB046107**



Supplier: ATG001-VC
A.T.G. Industries Inc
760 INDUSTRIELLE STREET
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalonde, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB046107

PO Date: 3/16/20

Due Date: 3/30/20

**Purchase Order
Revision:**

Revision Date:

Issued By: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

E-MAILED
2020-03-26

Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	205052	646.9713	646.9700 Rev H	Body Issue P/O to ATG Anodize, Color Black, Prime as per Dwg 646.9700	Firmed X20	-	3/30/20	20 pcs	0 pcs	20 pcs	\$16.08/pcs	\$321.60
												APR 6 2 2020
2	2071	D4726-1	D4726 Rev B	Handle : Various STC's Outsource4 (Outsource process-Anodize per QSI017 4.1.10.1)	Firmed X12	-	3/30/20	12 pcs	0 pcs	12 pcs	\$4.28/pcs	\$51.36
												MAR 2 6 2020
3	206659	646.9710	646.9700 Rev H	Body : Various STC's (Outsource process-Anodize per QSI017 4.1.10.1), Issue P/O to: Hard Black Anodize Color Black and Prime as per Dwg 646.9700	Firmed X12	-	3/30/20	12 pcs	0 pcs	12 pcs	\$9.08/pcs	\$108.96
												MAR 2 6 2020



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PURCHASE ORDER

POHB046107



Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
4	207949	RBEL135M-2905-101-03	RBEL135M-2905-101 Rev 9	Bottom Cover Outsource process- Anodize per QSI017 4.1.10.1 - Issue P/O to Groupe Altech; PO -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant -Certificate of Conformity is required	Firmed X5	-	3/30/20	5 pcs	0 pcs	5 pcs	\$9.91/pcs	\$49.55
MAR 26 2020												
5	207892	C45-1-1	C45-1-1 Rev 3	Manual Knob Release (Outsource process-Anodize per QSI017 4.1.10.1) -Issue PO -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE- 2 CLASS-2, Water sealant -Material type; 6061 -Certificate of Conformity is required As Per DWG C45- 1-1	Firmed X10	-	3/30/20	10 pcs	0 pcs	10 pcs	\$9.91/pcs	\$99.10
6	204806	647.3914	647.3900 Rev C2	Breakaway Tip, Long : Various STC's Outsource4 (Outsource process-Anodize per QSI017 4.1.10.1) Issue P/O to ATG :	Firmed X20	-	3/30/20	20 pcs	0 pcs	20 pcs	\$13.13/pcs	\$262.60
APR 02 2020												
Grand Total:												\$893.17

[Signature]



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PURCHASE ORDER

POHB046107



Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 3/26/20 10:13 AM Dart.Guerin.Kimberley



A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 919925

Date: 02-Apr-20

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Kimberley Guerin
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
20 ea	Part: 646.9713 Rev: H Body Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Batch/Lot#: Expiry Date: Job: 27153 Line: 1 PO: POHB046107		
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>APR 02 2020</u> Certified Signature: _____ Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.			

DA:
40
9-88

RECEIVED

APR 02 2020

DART AEROSPACE LTD.

Made in Canada.